Work Order ID 56048

February 9, 2010 1:22:59 PM

Item ID: D2858-2 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Hinge Bracket

Start Date: 2/09/10 **Start Qty:** 20.00 **Cust Item ID:**

Required Date: 2/15/10 **Req'd Qty:** 20.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2858	Rev B								
100	BAND SAW	0.00				21	0		
Bandsaw	**Memo**	0.00							
Jeaspa Bandsaw	Cut blanks 6.02" □Note: 1 Blank Makes 3 Parts								
110	HAAS CNC VERTICAL MACHINING #1	0.00				21	0		
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	1-Machine per folio D2858-2□2-Deburr								
120	QC2- Inspect parts off machine FAI/FAIB	0.00				21	0		
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				21	0		
QC	**Memo**	0.00							
Quality Control			10/02/14						
140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	**Memo**	0.00	=> M. L 10/02/16			21X			
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	M113170		=> JL 10/02/16			X21	0		
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 2:00pm OVEN TEMPERATURE: 320°F FINISH TIME: 2:30pm								

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 27	0.00							
Packaging	**Memo**	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

10-02-18 21

10/2/18 (21)

10/02/18

MF 10-2-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

February 9, 2010 1:23:03 PM

Work Order ID: 56048

Parent Item: D2858-2

Parent Item Name: Hinge Bracket

Start Date: 2/09/10 **Required Date:** 2/15/10

Comments: IPP □C□00.06.22□Removed P/O for powder coat□EC□

Start Qty: 20.00 **Required Qty:** 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X01.250		Purchased	No			110	f	60.0842	3.5432			

6061-T6 Bar 1.50 x 1.25

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	60.08415	
107461	11.84	
→ 110936	48.24415	

3.5432 ML 10/02/10

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	560418
Description: Hinge Bracket	Part Number:	D2858-2
Inspection Dwg: D2858 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.000	.174	✓			
Ø0.400	+0.005/-0.000	.400	✓			
R0.125	+/-0.010	.125	✓			
0.328	+/-0.010	.328	✓			
0.820	+/-0.005	.819	✓			
1.476	+/-0.010	1.478	✓			
0.342	+/-0.010	.345	✓			
0.875	+/-0.010	.875	✓			
1.56	+/-0.030	1.563	✓			
0.147	+/-0.010	.140	✓			
0.717	+/-0.010	.719	✓			
0.697	+/-0.010	.694	✓			
0.229	+/-0.010	.234	✓			
R0.125	+/-0.010	.125	✓			
R0.063	+/-0.010	.063	✓			
0.063	+/-0.010	.065	✓			
0.126	+/-0.010	.126	✓			
0.630	+/-0.010	.627	✓			
R0.354	+/-0.010	.354	✓			
0.965	+/-0.010	.964	✓			
Ø0.166	+0.005/-0.000	.167	✓			

Measured by:	S.F	Audited by:	MMF	Prototype Approval:	N/A
Date:	10/02/11	Date:	10/02/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	

Dart Aerospace Ltd

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DART

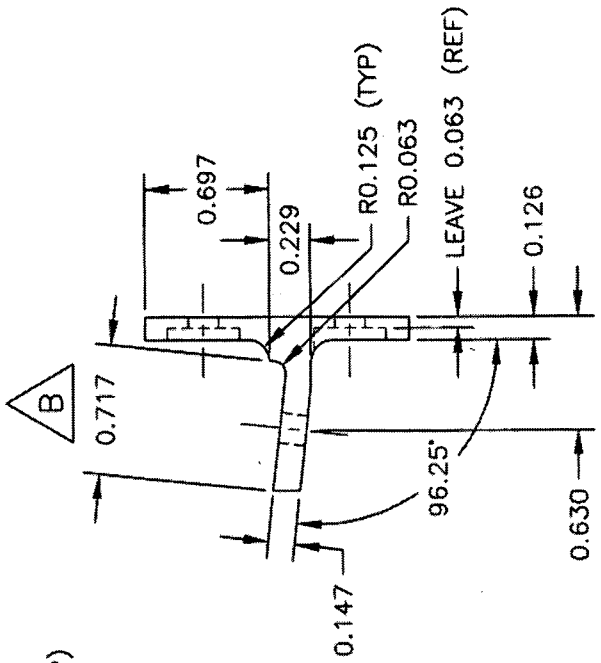
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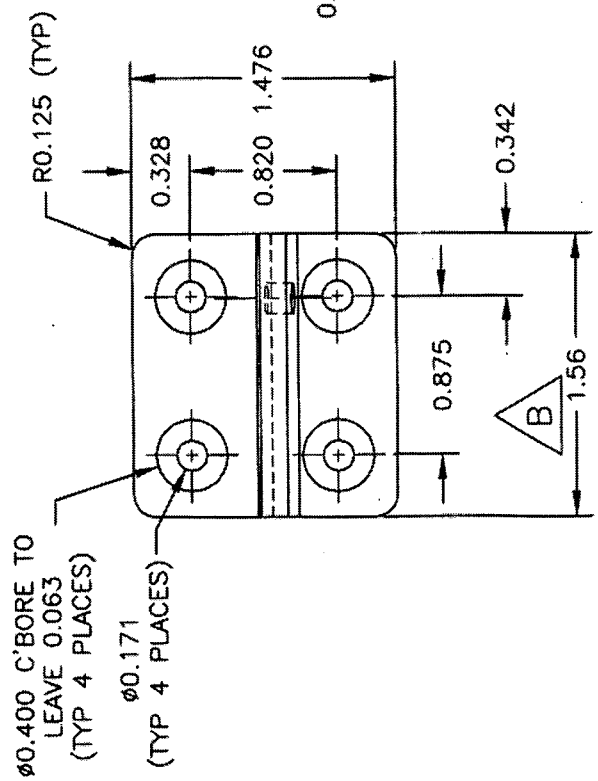
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2858 — REV. B — SHEET 1 OF 1
DATE 99.02.28		TITLE HINGE BRACKET — SCALE 1:1

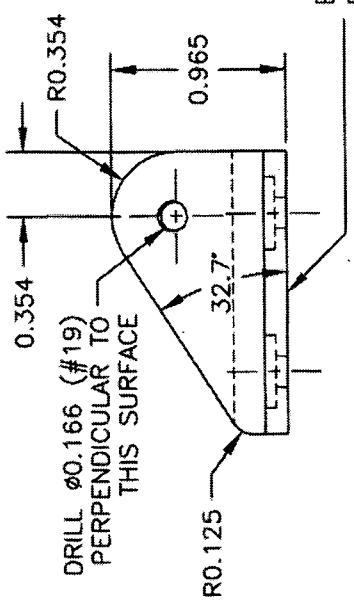
A	98.12.14	NEW ISSUE
B	99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559

RELEASED
99.03.03 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDM
WITHOUT NOTICE
WORK ORDER
NO. 36078
RM 10-2-09







D2858-1 SHOWN
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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